



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D3913-041**  
**Job Sheet 184109**



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/3/18

Job Tracking No:

Due Date: 10/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |          | Workcenter/Supplier   |           | Sign-off      |
|-------|--------------------|-------|------------|----------|-----------|----------|-----------------------|-----------|---------------|
|       |                    |       |            |          | Setup hrs | Run/ Hrs | Workcenter / Supplier | Lead Time |               |
| 90    | Start up Operation | 1 Ea  | 10/31/18   | 10/31/18 | 0.00      | 0.00     | Start Up Large Fab-5  |           | DC 2018-10-16 |
| 100   | Large Fab          | 1 pcs | 10/31/18   | 10/31/18 | 0.00      | 10.00    | Large Fab 1           |           | C 2018-10-23  |
| 110   | QC                 | 1 pcs | 10/31/18   | 10/31/18 | 0.00      | 0.00     | QC9                   |           | CPC           |
| 120   | QC                 | 1 pcs | 10/31/18   | 10/31/18 | 0.00      | 0.00     | QC5                   |           | CPC           |
| 125   | HandFinish         | 1 pcs | 10/31/18   | 10/31/18 | 0.00      | 0.29     | HandFinish2           |           | 18-11-01      |
| 130   | Powdercoat         | 1 pcs | 10/31/18   | 10/31/18 | 0.00      | 0.93     | Powdercoat2           |           | 18-11-02      |
| 135   | Packaging          | 1 pcs | 10/31/18   | 10/31/18 | 0.00      | 0.00     | Packaging1            |           | 18-11-02      |
| 140   | QC                 | 1 pcs | 10/31/18   | 10/31/18 | 0.00      | 0.00     | QC3                   |           | 18-11-02      |
| 150   | HandFinish         | 1 pcs | 10/31/18   | 10/31/18 | 0.00      | 0.50     | HandFinish4           |           | 18-11-02      |
| 160   | QC                 | 1 pcs | 10/31/18   | 10/31/18 | 0.00      | 0.00     | QC5                   |           | 18-11-02      |
| 170   | Packaging          | 1 pcs | 10/31/18   | 10/31/18 | 0.00      | 0.00     | Packaging3-2          |           | 18-11-02      |
| 180   | QC21-SA            | 1 Ea  | 10/31/18   | 10/31/18 | 0.00      | 0.00     | QC21                  |           | NOV 02 2018   |

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A \*\*\*inspect before welding mesh\*\*\* 2- Cut D4020-1 base  
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners  
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 \*\*\*\*take lid to locate hinge and bracket\*\*\* 4-  
Weld D4672-1 blanking plates as per dwg  
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat  
150 - Pick Kit

M 138951.8:10

START

OUT: 375° FINISH: 8:25

### Job BOM

| Part / Item | Component Name    | Quantity    | Operation             | Container |
|-------------|-------------------|-------------|-----------------------|-----------|
| D2581       | Mounting Bracket  | 2 Ea (2 ea) | 90-Start up Operation | S105222   |
| D3913-1     | Rib               | 1 Ea (1 ea) | 90-Start up Operation | S112746   |
| D3913-15    | Wide Handle Plate | 1 Ea (1 ea) | 90-Start up Operation | S108592   |
| D3913-3     | Rib               | 1 Ea (1 ea) | 90-Start up Operation | S112730   |
| D3913-7     | Rib               | 2 Ea (2 ea) | 90-Start up Operation | S104485   |
| D3913-9     | Hinge Rib         | 1 Ea (1 ea) | 90-Start up Operation | S115925   |
| D3916-041   | Rib Assembly      | 2 Ea (2 ea) | 90-Start up Operation | S111464   |
| D3916-5     | Light Rib         | 3 Ea (3 ea) | 90-Start up Operation | S112380   |
| D4016-1     | Hinge Half, Base  | 3 Ea (3 ea) | 90-Start up Operation | S115309   |
| D4017-7     | Rib               | 3 Ea (3 ea) | 90-Start up Operation | S110037   |
| D4017-9     | Rib               | 2 Ea (2 ea) | 90-Start up Operation | S115755   |



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                              |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                            |                                                 |                                               |
|--------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------|-------------------------------------------------|-----------------------------------------------|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |                                                            |                                                 |                                               |
| Date :                                                       | Step #:                                                                                                                                                                            | QTY Effective :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                            | MRB (QSI042) Approval                           |                                               |
| Description Work Order Deviation                             |                                                                                                                                                                                    | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                            | Completed By                                    |                                               |
|                                                              |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                            | Lead hand / Supervisor<br>Approval Verification |                                               |
|                                                              |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                            | QC / QA Coordinator<br>Approval                 |                                               |
|                                                              |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                            |                                                 |                                               |
| Root Cause                                                   |                                                                                                                                                                                    | FAULT CATEGORY                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                            |                                                 |                                               |
| Environment <input type="checkbox"/>                         | No Re-verification <input type="checkbox"/>                                                                                                                                        | Pressure/Forced <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | Temperature/Cure <input type="checkbox"/>                  | Power Loss/Surge <input type="checkbox"/>       | Positioned Wrong <input type="checkbox"/>     |
| Design <input type="checkbox"/>                              | Operator <input type="checkbox"/>                                                                                                                                                  | Bending <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Set-up <input type="checkbox"/>                            | Folio/Program <input type="checkbox"/>          | Outside Dimensions <input type="checkbox"/>   |
| Doc/Data <input type="checkbox"/>                            | Offset/Setup <input type="checkbox"/>                                                                                                                                              | Centre Not Concentric <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | BOM/Route <input type="checkbox"/>                         | Grain <input type="checkbox"/>                  | Over/Under tolerance <input type="checkbox"/> |
| Equip/Tooling <input type="checkbox"/>                       | Supplier <input type="checkbox"/>                                                                                                                                                  | Cracks <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Broken/Damage/Defect <input type="checkbox"/>              | Weld <input type="checkbox"/>                   | Part Incorrect <input type="checkbox"/>       |
| Handling/Pre <input type="checkbox"/>                        | Training <input type="checkbox"/>                                                                                                                                                  | Crimp/Kink/Ripple/Wave <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Inspection Incomplete/Unqualified <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/>     | Part Lost/Missing <input type="checkbox"/>    |
| Material <input type="checkbox"/>                            | Use for Testing <input type="checkbox"/>                                                                                                                                           | Cuffs <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | Contamination <input type="checkbox"/>                     | Out of Sequence <input type="checkbox"/>        | Part Moved <input type="checkbox"/>           |
| Internal Transport <input type="checkbox"/>                  | Poor Information <input type="checkbox"/>                                                                                                                                          | Crushing <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | Countersink <input type="checkbox"/>                       | Off-set <input type="checkbox"/>                | Drawing <input type="checkbox"/>              |
| Tribal Knowledge <input type="checkbox"/>                    | Rushing <input type="checkbox"/>                                                                                                                                                   | Heat Treat <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Cut Too Short <input type="checkbox"/>                     | Mislabeled <input type="checkbox"/>             | Finish <input type="checkbox"/>               |
| LOA <input type="checkbox"/>                                 | Product Improvement <input type="checkbox"/>                                                                                                                                       | Wave/Twist in Tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Instructions Incomplete/Unclear <input type="checkbox"/>   | Fit/Function <input type="checkbox"/>           | Misread <input type="checkbox"/>              |
| Substation <input type="checkbox"/>                          | Process Improvement <input type="checkbox"/>                                                                                                                                       | Marks/Chatter <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | Drill Holes <input type="checkbox"/>                       | Misaligned/off center <input type="checkbox"/>  | Turning Sequence <input type="checkbox"/>     |
| Past Expiry Date <input type="checkbox"/>                    | Manufacturing Process <input type="checkbox"/>                                                                                                                                     | OTHER :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                            |                                                 |                                               |
| Misidentified <input type="checkbox"/>                       | Past Due <input type="checkbox"/>                                                                                                                                                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                            |                                                 |                                               |



|                |                        |               |                       |
|----------------|------------------------|---------------|-----------------------|
| D4020-11       | End Mesh, Basket       | 2 Ea (2 ea)   | 90-Start up Operation |
| D4021-1        | Handle Plate           | 3 Ea (3 ea)   | 90-Start up Operation |
| D4034-041      | Aft Upper Rib Assembly | 1 Ea (1 ea)   | 90-Start up Operation |
| D4034-043      | Fwd Upper Rib Assembly | 1 Ea (1 ea)   | 90-Start up Operation |
| D4672-1        | Blanking Plate         | 2 Ea (2 ea)   | 90-Start up Operation |
| M304EX0.75-16F | Expanded Metal Flat SS | 33 sf (33 ea) | 90-Start up Operation |
| AN3-10A        | Bolt                   | 6 Ea (6 ea)   | 150-HandFinish        |
| D2931          | Bumper                 | 2 Ea (2 ea)   | 150-HandFinish        |
| MS20600-AD4W3  | Cherry Rivet           | 2 Ea (2 ea)   | 150-HandFinish        |
| MS21042L3      | Nut                    | 6 Ea (6 ea)   | 150-HandFinish        |
| NAS1149F0332P  | Washer                 | 12 Ea (12 ea) | 150-HandFinish        |
| D4021-5        | Blanking Plate         | 2 Ea (2 ea)   | 150-HandFinish        |

~~318789~~ S109707  
S108580  
S113926  
S113925  
S114035  
S093684  
S106952  
F86435  
S076007  
S094592-1  
S109991  
S108637

### Job Allocations

006247

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D2581          | 2        | 76        | 0         |
|                       | D3913-1        | 1        | 10        | 0         |
|                       | D3913-15       | 1        | 24        | 0         |
|                       | D3913-3        | 1        | 11        | 0         |
|                       | D3913-7        | 2        | 6         | 0         |
|                       | D3913-9        | 1        | 5         | 0         |
|                       | D3916-041      | 2        | 12        | 0         |
|                       | D3916-5        | 3        | 17        | 0         |
|                       | D4016-1        | 3        | 199       | 0         |
|                       | D4017-7        | 3        | 31        | 0         |
|                       | D4017-9        | 2        | 6         | 0         |
|                       | D4020-11       | 2        | 21        | 0         |
|                       | D4021-1        | 3        | 47        | 0         |
|                       | D4034-041      | 1        | 5         | 0         |
|                       | D4034-043      | 1        | 5         | 0         |
|                       | D4672-1        | 2        | 22        | 0         |
|                       | M304EX0.75-16F | 33       | 1,601     | 0         |
| 150-HandFinish        | AN3-10A        | 6        | 239       | 0         |
|                       | D2931          | 2        | 950       | 0         |
|                       | D4021-5        | 2        | 36        | 0         |
|                       | MS20600-AD4W3  | 2        | 345       | 0         |
|                       | MS21042L3      | 6        | 2,933     | 0         |
|                       | NAS1149F0332P  | 12       | 3,011     | 0         |

### Part Specifications

Specifications could not be found.

